

# Work Order ID 63503



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Wednesday, November 03, 2010 11:12:00 A

Item ID:	D350-591-311	Accept		Setup	Start	
Revisor ID:					Stop	
Item Name:	Heli-Access-Step, Long LH					
Start Date:	11/3/2010	Start Qty:	10.00	Cust Item ID:		
Required Date:	12/10/2010	Req'd Qty:	10.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-11-03	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100		DC	Document Control	DOCUMENT CONTROL	0.00						
				Memo	0.00						
				Photocopy bluefile and type labels as per PPP D350-591-311							
110		Large Fab	Large Fab	Large Fab	0.00						
				Memo	0.00						
				1-Bevel end for welding FWD ONLY							
				2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272							
				A/R <input type="checkbox"/> Aluminum Rod							
				3-Grind End Plate flush							

10/12/08  
84  
CH4001  
Eurocopter  
10-11-25  
10  
J

10-12-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Item ID: D350-591-311

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Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 11/3/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10 0 BER 11/29

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 10/14/29 / M/M



140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10 11-30

10 0

W/O:		WORK ORDER CHANGES					
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Required Date: 12/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

7 10/11/30

10 Re 0

Memo

0.00

180



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Assemble Leg Assembly as per Dwg D3272.

10.12.01

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272  
A/R ☐ Aluminum Rod ☒ M108436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10 0

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10 0 BE10/12/02

200



QC

Quality Control

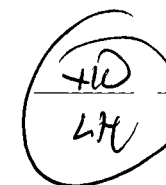
QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SI 10/12/02



210



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10/12/03

10 LTI 0

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115951.</i> Memo START TIME: <i>10:35</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:05.</i>	0.00  0.00				<i>18</i>	<i>BR</i>	<i>10-12-3.</i>	
230  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M115790</i> Memo	0.00  0.00				<i>X104H</i>	<i>8</i>		
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00  0.00				<i>410</i> <i>LH</i>			

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Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10/12/10 5/10/10

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/21/2010

X10  
LH

270



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD350-591-311

Location: \_\_\_\_\_

B

10/12/10 10/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/08  
MF  
10-12-08

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

Wednesday, November 03, 2010 11:12:04 AM





Page 1

[illegible]

**Required Date:** 12/10/2010

**Required Qty: 10.00**

**Comments:** IPP Rev:A 04.03.22 New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC  
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1  End Plate		Manufactured	No			110	Each	136.0000	1	10		10.11.25	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			136						
				60141			5						
				<u>62664</u>			131			10			
D3219-1  Plate		Manufactured	No			110	Each	61.0000	2	20		10.11.25	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA			61			15			
				<u>61204</u>			61			5			
D3272-1  Step		Manufactured	No			110	Each	0.0000	1	10		10.11.19	36351
D3065-041  Step Leg Assembly Hi		Manufactured	No			180	Each	162.0000	1	10		10.11.30	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST			134						
				<u>63324</u>			134			10			
				WA			28						
				61216			3						
				<u>62224</u>			25						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63503

Parent Item: D350-591-311

Parent Item Name: Heli-Access Step, Long LH

Start Date: 11/3/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D3066-1  
Spacer

Manufactured No

180 Each

87.0000 2 20

Location

Loc Qty

Loc Code

WA

B63549

87

62662

87

D3067-1  
End Plate

Manufactured No

180 Each

136.0000 1 10

Location

Loc Qty

Loc Code

WA

136

60141

5

62664

131

MS20600-AD4W4  
Rivets

Purchased No

180 Each

1,875.000 16 160

Location

Loc Qty

Loc Code

ST321

1875

113368

38

114181

11

114718

2

115573

147

115640

677

116022

1000

AN3-35A  
Bolt

Purchased No

250 Each

139.0000 2 20

Location

Loc Qty

Loc Code

ST353

139

115457

39

115936

100

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 63503

Parent Item: D350-591-311

Parent Item Name: Heli-Acc's-Step, Long LH

Start Date: 11/3/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

413.0000

8

80



Bolt

Location

Loc Qty

Loc Code

ST357

300

115936

300

ST358

113

115159

113

10/12/10 sl MIG191

AN5-36A

Purchased

No

250

Each

147.0000

2

20



Bolt

Location

Loc Qty

Loc Code

ST340

100

115936

100

ST341

47

114292

5

114941

42

34

10/12/10 sl

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

8.0000

4

40



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

20

11/15/10 sl

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

24.0000

16

160



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

11/16/10 sl

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Start Date: 11/3/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD516 NAS1149D0563J Purchased No

250 Each

34.0000 4 40



1114742 10/12/05

Washer

## Location

## Loc Qty

## Loc Code

ST 34  
103694 18  
107534 12  
109287 4

D2230-3

Manufactured No

250 Each

90.0000 4 40



24x B63544 10/12/05

Lug

## Location

## Loc Qty

## Loc Code

ST476 90  
55452 2  
62660 88

B63992 (16) 10/12/08

D2618

Manufactured No

250 Each

153.0000 2 20



10/12/05 102

Bushing

## Location

## Loc Qty

## Loc Code

ST019 151  
60772 51  
62213 100  
ST020 2  
56892 1  
57829 1

80

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Start Date: 11/3/2010

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Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

175.2500 0.6



Abraison Strip



10/12/6sf

Location

Loc Qty

Loc Code

ST403

175.2500421

56626

0.00004211

59920

175.25

Manufactured No

250 Each

57.0000 2

D3235-1



Mounting Lug



20  
B62214 10/12/6sf

Location

Loc Qty

Loc Code

ST471

57

60851

20

61845

37

Manufactured No

250 Each

62.0000 1

D3278-041



Support Assembly



10  
10/12/6sf

Location

Loc Qty

Loc Code

ST471

62

61212

32

62395

30

Purchased No

250 Each

1,890.000 2

MS21042L3



Nut



10  
20  
10/12/6sf 100

Location

Loc Qty

Loc Code

ST300

1890

114784

890

115835

1000

20

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Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

2,781.000

8

80



10/12/10 sf

Nut

8-10

## Location

## Loc Qty

## Loc Code

ST300

2781

113422

25

114523

8

115589

1648

115621

1100

80

MS21042L5

Purchased

No

250

Each

747.0000

2

20



10/12/10 sf (102)

Nut

8-10

## Location

## Loc Qty

## Loc Code

ST139

26

114813

26

ST300

721

115156

221

115594

500

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>92</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07 06 04 *ff***REFERENCE ONLY**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

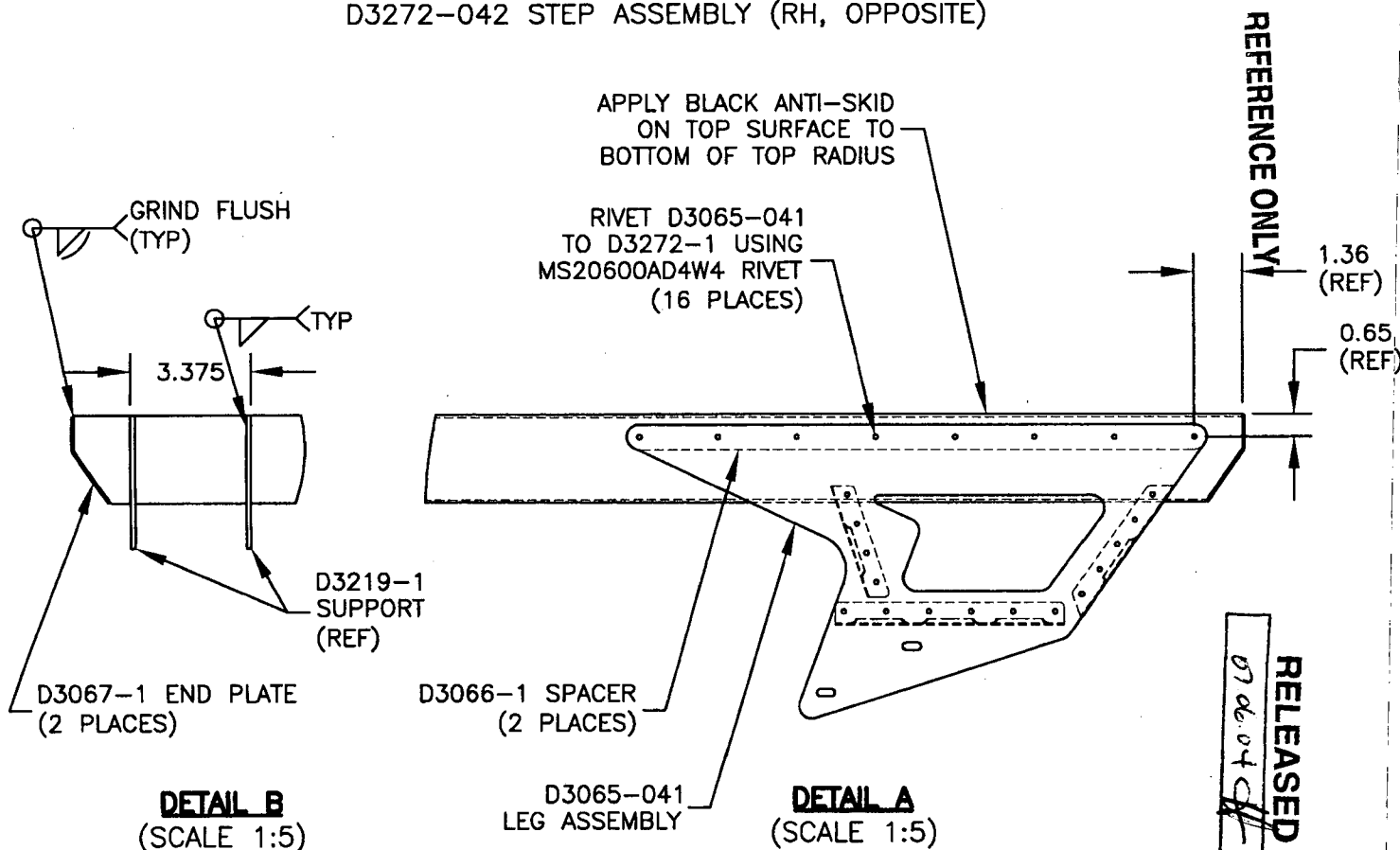
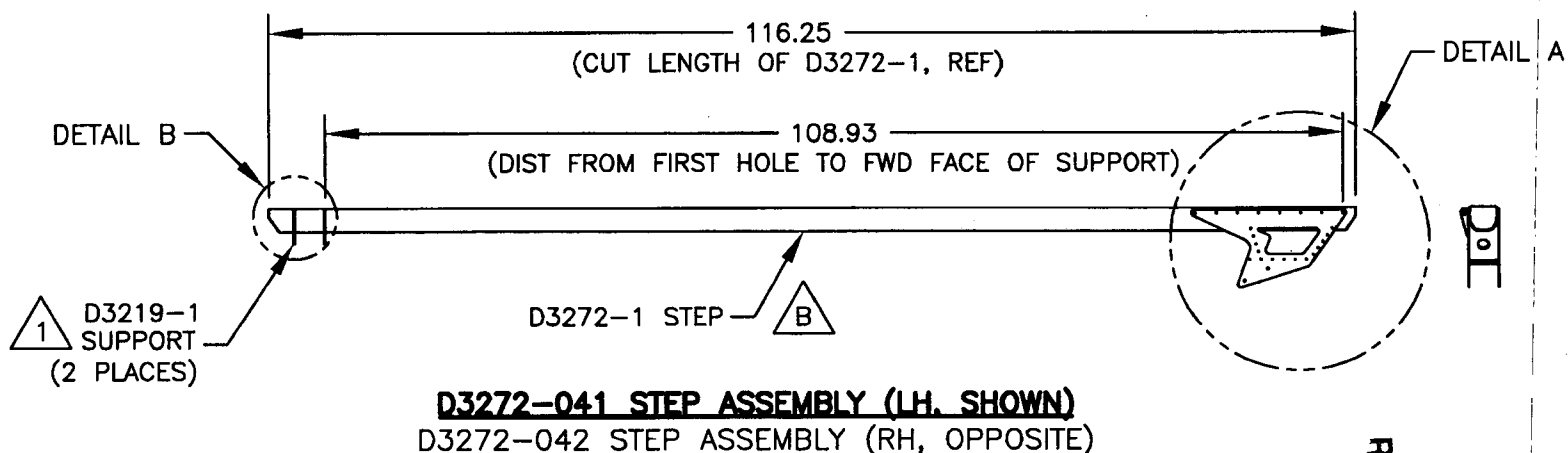
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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**DART**

DESIGN	CH	DRAWN BY	JB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JB	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



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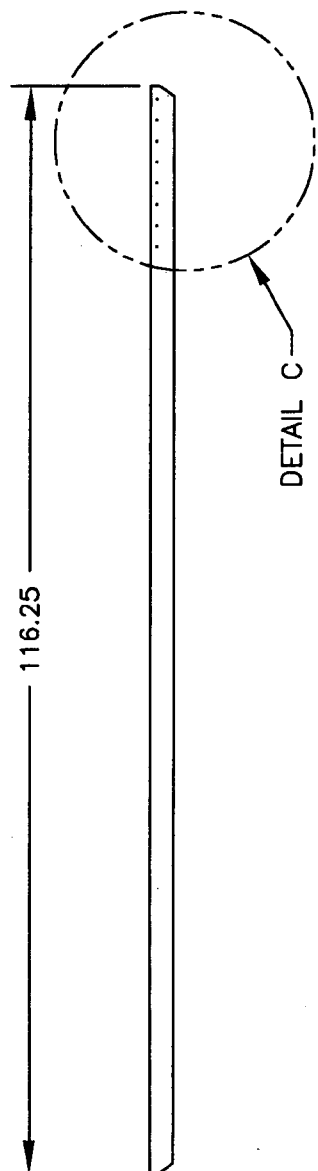


DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

REFERENCE ONLY

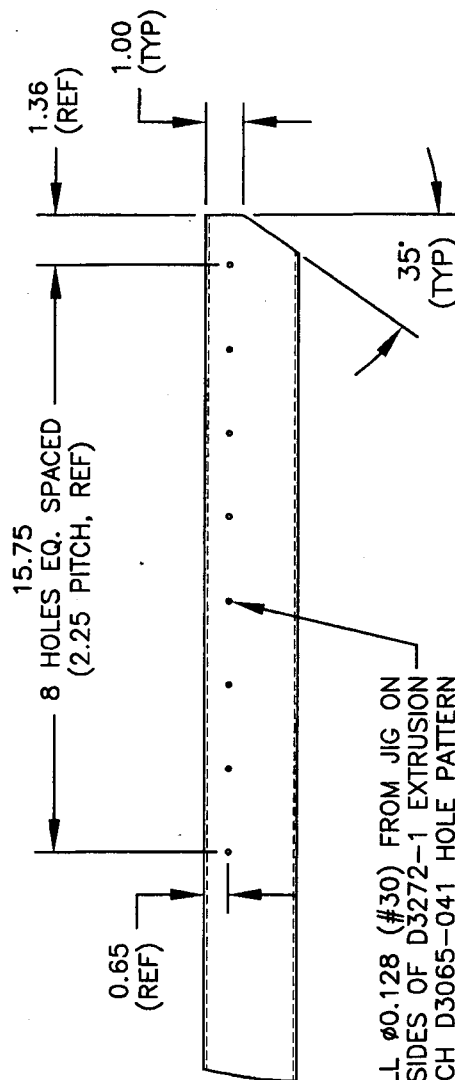
RELEASED

07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G

Date: 08.10.06